

# Work Order ID 78054

December-28-11 9:18:42 AM

**\*78054\***

Page 1

Item ID: D3686-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: MONOPOD ASSEMBLY  
 Start Date: 12/28/11 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 12/28/11 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference: disassemble

Approvals: Process Plan: W Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3686	E								

110  
**\*110\***  
 Small Fab  
 Small Fab

Small Fab

Memo  
 PULL FROM STOCK:  
 1 X D3686-041 B67923  
 REMOVE ROD END BEARING  
 D3693-3 B50723  
 RETURN TO STK FOR S/O106743 n

REPLACE WHEN AVAILABLE  
 D3693-3 B 77720  
 1- Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent  
 on thread and assemble as per dwg D3686  
 \*\*\*\*\*ENSURE THERE IS ANTI-SEIZE ON FULL LENGTH OF  
 THREAD\*\*\*\*\*

A/R Anti-Seize Batch: 111791

2- Assemble D3693-1 & D3691-1 & D3693-3 & D3688-7 Using Sikaflex -241/-  
 291 between mating surfaces as per Dwg D3686  
 \*\*\*Ensure holes for AN3C Bolts are free of sealant.  
 Torque Fastners as per Dwg D3686\*\*\*

A/R Sikaflex Batch: 1119508

EF 11/2/28 ①

80/FF 12-01-27

80/FF 12-01-27

80/FF 12-01-27

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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location <i>SI 128</i>	0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging	RE-IDENTIFY USING NEW B/N								
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

*12/26/127*

*tc*

*10 SP 12-01-27*

*12/2/11*

*mf 12-01-31*

# Picklist Print

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Page 1

Work Order ID: 78054

Parent Item: D3686-041

Parent Item Name: MONOPOD ASSEMBLY

Start Date: 12/28/11

Required Date: 12/28/11

Start Qty: 1.00

Required Qty: 1.00

**Comments:**

IPP Rev:A new issue 08-02-12 DD verified by:JLM  
 IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC  
 03-16 JLM VERIFIED BY:EC  
 IPP Rev:D Added sealant note as per Rev C 09-01-20 JLM  
 Verf:DD  
 revE DD verf:EC

IPP REV:C AS PER REV D 10-

IPP REV:E 11.12.05 as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3686-041 MONOPOD ASSEMBLY		Manufactured	No				Each	2.0000		1		67923	u
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Location

Loc Qty

Loc Code

ST077

2

77303

2

D3693-3

Rod End Bearing

Manufactured No

Each 0.0000

1

FF 12-01-27

D3693-3

Rod End Bearing

Manufactured No

Each 0.0000

-1

FF 12-01-27

2 AN3C10A

112489  
m 120423

(2x)

FF

12-01-27

D3692-1

B 73232

(4x)

FF

12-01-27

MS 21043-3

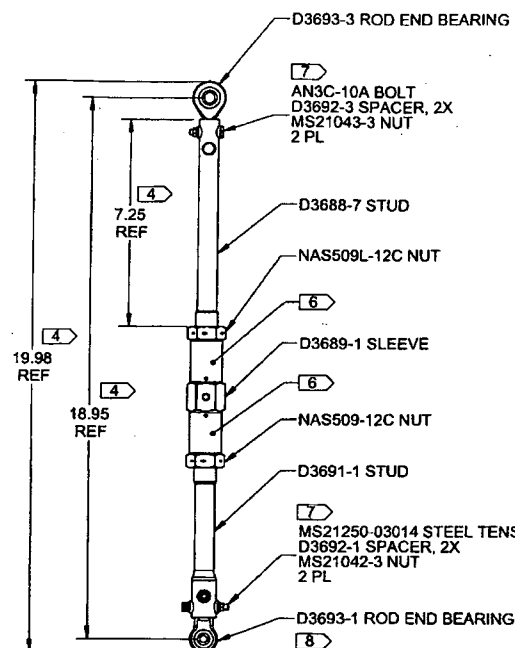
m 119901

(4x)

FF

12-01-27

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3686-041	MONOPOD ASSEMBLY
2	1	D3688-7	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	4	D3692-3	SPACER
7	1	D3693-1	ROD END BEARING
8	1	D3693-3	ROD END BEARING
9	2	AN3C-10A	BOLT
10	2	MS21042-3	NUT
11	2	MS21043-3	NUT
12	2	MS21250-03014	STEEL TENSION BOLT
13	1	NAS509L-12C	NUT
14	1	NAS509-12C	NUT



**D3686-041 MONOPOD ASSEMBLY**

**NOTES:**

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3686-041 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-7 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.0 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 & D3693-3 WITH D3688-7 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

E	QTY(2) MS21250-03014 STEEL TENSION BOLTS AND QTY(2) MS21042-3 NUT REPLACE QTY(2) AN3C12A BOLTS AND QTY(2) MS21043-3 NUT (ZN B3-1 & C6D8-1) REASON: PRODUCT IMPROVEMENT (REF. NCR11-784)	MB	11.11.23
D	19.98 WAS 20.10 (ZN C8-1); 18.95 WAS 19.07 (ZN C8-1)	RF	10.03.03
C	ROD END BEARINGS NOW ASSEMBLED USING SEALANT (ZN AB-1, B4-1)	RF	08.12.15
B	REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.11.23		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3686** REV. E  
SHEET 1 OF 1  
TITLE **MONOPOD ASSEMBLY** SCALE NTS

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**RELEASED**  
2011-12-01

# Picklist Print

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Tuesday, April 05, 2011 9:58:05 AM

Work Order ID: 67923

Parent Item: D3686-041

Parent Item Name: MONOPOD ASSEMBLY

Start Date: 4/4/2011

Required Date: 4/8/2011

Start Qty: 2.00

Required Qty: 2.00

D3692-3

Manufactured No

110

Each

23.0000

4

8



SPACER

Location

Loc Qty

Loc Code

ST075

23

44690

23

D3693-1

Manufactured No

110

Each

22.0000

1

2



Rod End Bearing

Location

Loc Qty

Loc Code

GA

22

50734

22

D3693-3

Manufactured No

110

Each

2.0000

1

2



Rod End Bearing

Location

Loc Qty

Loc Code

GA

2

50723

2

AN3C10A

Purchased No

110

Each

28.0000

2

4



Bolt

Location

Loc Qty

Loc Code

ST351

28

105940

8

112489

20

AN3C12A

Purchased No

110

Each

41.0000

2

4



Bolts

Location

Loc Qty

Loc Code

ST351

41

116924

41

1117794

②

12

Tuesday, April 05, 2011 9:58:06 AM

Shop Packet Print

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